

Date: Wednesday, 11/21/2007 12:51:39 PM  
 User: Kim Johnston

## Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : FLOOR PROTECTOR LH
Job Number : 35945	
Estimate Number : 11226	
P.O. Number : <i>N/A</i>	Part Number : D32801
This Issue : 11/21/2007	Drawing Number : D3280 REV <i>B C</i>
S.O. No. : <i>N/A</i>	Project Number : <i>N/A</i>
Prsht Rev. : NC	Drawing Revision : <i>B C</i>
First Issue : <i>N/A</i>	Material : <i>N/A</i>
Type : THERMOFORMING	Due Date : 11/28/2007
Previous Run : 35244	Qty: 5 UoM: Each
Written By : _____	
Checked & Approved By : _____	
Comment : Est Rev:A 04.07.01 New issue KJ/JLM	
Est RevB 07.09.12 Thermoform in house DL	

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	F6006 701	lexan black
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*M 105952*

Comment: Qty.: 4.0000 sf(s)/Unit Total : 20.0000 sf(s)  
 lexan black

2.0	HAND FINISH TH	HAND FINISHING THERMOFORMING
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Comment: HAND FINISHING THERMOFORMING

1) Cut Blanks

*BB/07/11/22 X5*

3.0	THERMOFORMING	THERMOFORMING MACHINE
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Comment: THERMOFORMING MACHINE

Thermoform as per Dwg. D32811 and Folio FTA 011

Dwg. Rev. *C*  
 Folio Rev. *B*

*BB/07/11/23 X5*

4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

*BB/07/11/26 PTO →*

5.0	HAND FINISH TH	HAND FINISHING THERMOFORMING
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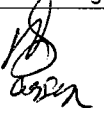


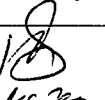

Comment: HAND FINISHING THERMOFORMING

1) Trim to Finished Dimensions

*BB/07/11/26 X5*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☒ No ☐ DQA: ☒ Date: 01/11/20  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
07/11/22	4	overheated. R.C. Hammer error		Swap & replace. Qty 1	 07/11/22	 07/11/26	 07/11/26	 07/11/26

NOTE: Date & initial all entries

Date: Wednesday, 11/21/2007 12:51:39 PM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FLOOR PROCTOR LH

Job Number: 35945

Part Number: D32801

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

1) Check Surface finish for undesired marks, voids, dimples etc.

2) Check dimensions to ensure conformity to drawing tolerances.

DL- 07/11/26-

7.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

6 7/16/26 (XS)

8.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

ST 272

KS 07/11/28

(XS)

9.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

3  
07/11/30

Job Completion



W 07.11.30

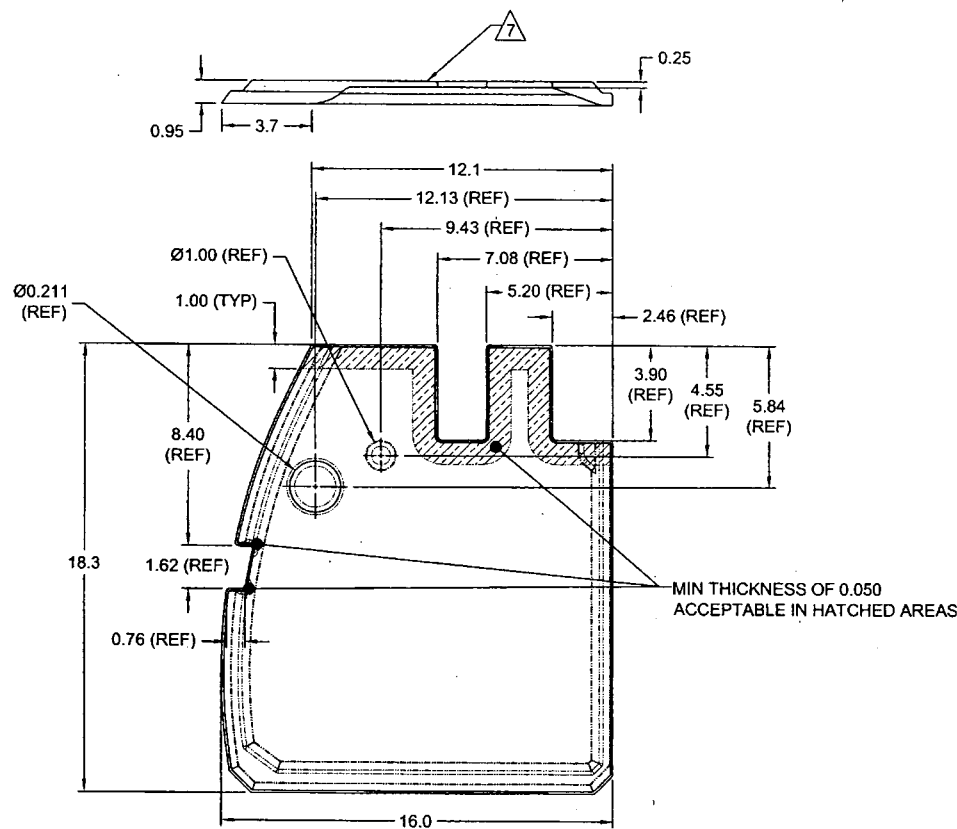
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



**D3280-1 FLOOR PROTECTOR**

**D3280-1 NOTES:**

- 1) THERMOFORM WITH MOLD D3280-1T1 PER DART QSI 022; TRIM AS SHOWN  
MINIMUM THICKNESS AFTER FORMING: 0.080" EXCEPT WHERE INDICATED
- 2) MATERIAL: LEXAN F6006, BLACK No. 701, 0.125" THICK  
(REF DART SPEC MLEXS.125-F6006-02)
- 3) FINISH: NONE
- 4) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) UNITS: INCHES UNLESS OTHERWISE NOTED
- 6) BREAK SHARP EDGES: 0.010 MAX
- 7) IDENTIFICATION: IDENTIFY WITH DART P/N "D3280-1" ON SMOOTH SIDE OF PART USING WHITE PAINT MARKER
- 8) WEIGHT: 1 lb

C	UPDATE DIMS TO MATCH PARTS; COLOUR 701 WAS 700; GENERAL UPDATE	LE	07.10.12
B	NOW LEXAN; DIMS AS MANUFACTURED	CP	05.11.25
A	NEW ISSUE	CP	04.05.03
REV.	DESCRIPTION	BY	DATE
DESIGN	GP		
DRAWN	CE		
CHECKED	PA		
MFG. APPR.	LA		
APPROVED	TH		
DE APPR.	CH		
DATE	07.10.12		

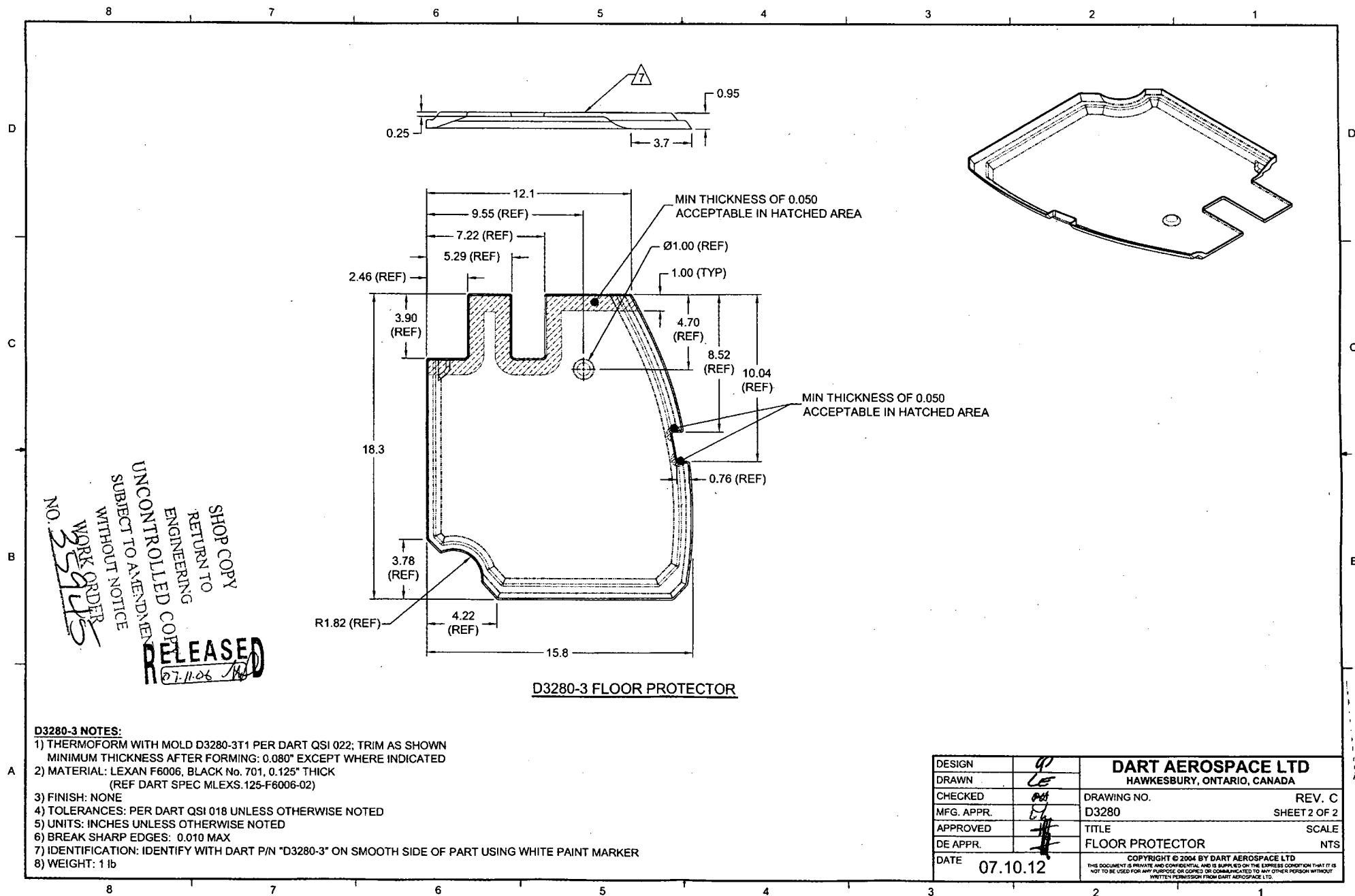
**DART AEROSPACE LTD**  
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. D3280  
REV. C  
SHEET 1 OF 2

TITLE FLOOR PROTECTOR  
SCALE NTS

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NO. 55945  
WORK ORDER  
SUBJECT TO AMENDMENT  
UNCONTROLLED COPY  
ENGINEERING  
RETURN TO  
SHOP COPY  
RELEASED  
07.11.06



DART AEROSPACE LTD		Work Order:	35945
Description: R32 FLOOR PROTECTOR LH-		Part Number:	D 3280-1
Inspection Dwg: D3280 Rev: C		Page 1 of 1	

### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

### THERMOFORMING SECTION

Description	Accept	Reject	Method of Inspection	Comments
Inside Radii less than <u>3/16</u> "	✓		gauge.	
Shape Definition	✓		VIS	
Texture Retention	✓		VIS	
Material imperfections such as bumps, cracks, voids, scratching	✓		VIS.	

Measured by: <u>Dh</u>	Date: <u>07.11.22</u>
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### TRIMMING SECTION

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
18.3	.100	18.375	✓		TAPE	
16.0	.100	16.0	✓		TAPE	
12.1	.100	12.125	✓		TAPE	
.95	.030	.979	✓		CAL.	
.25	.030	.274	✓		CAL.	

Measured by: <u>Dh</u>	Date: <u>07.11.26</u>
Audited by: <u>S. Sulu/26</u>	Date:
Prototype Approval:	Date:

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/DL	